

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010360**Date Inspected:** 25-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** Zhu zhong hai  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** Yes No N/A  
**Approved WPS:** Yes No N/A  
**Delayed / Cancelled:** Yes No N/A

**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 2F-007 located on PCMK SEG049B of 9AW welder is identified as 0201215.ZPMC QC is identified as Mr.Li ming yang . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 1G-001 located on PCMK SEG051B of 9BW welder is identified as 045175.ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F.

FCAW welding of weld joint 3G-015 located on PCMK SEG055D welder is identified as 047866.ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-4233-TC-U4b-F.

BAY#13

SMAW welding of weld joint 4G-010 located on PCMK SEG067A of 11BW welder is identified as 067656. ZPMC QC is identified as Mr. Zhang qiao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-TC-U4b-FCM-1.



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FCAW welding of weld joint 1G-221 located on PCMK SSD14A-PP101 of 11CW welder is identified as 044774. ZPMC QC is identified as Mr. Zhong qiao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-TC-U4b-F.

SMAW welding of weld joint 4G-127 located on PCMK SSD13A-PP97 of 11AW welder is identified as 067764. ZPMC QC is identified as Mr. Zhang qiao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-TC-U4b-FCM-1.

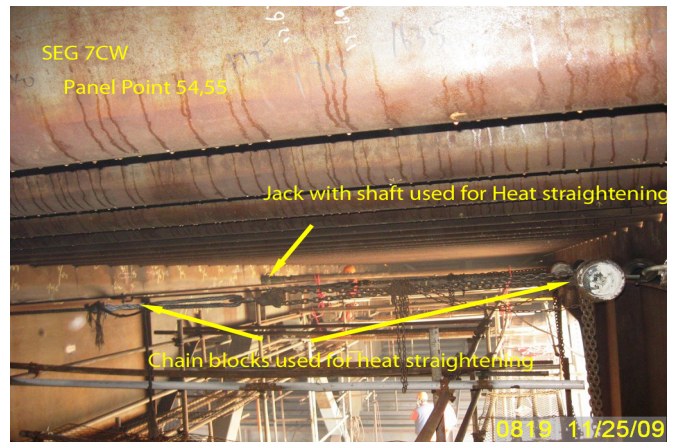
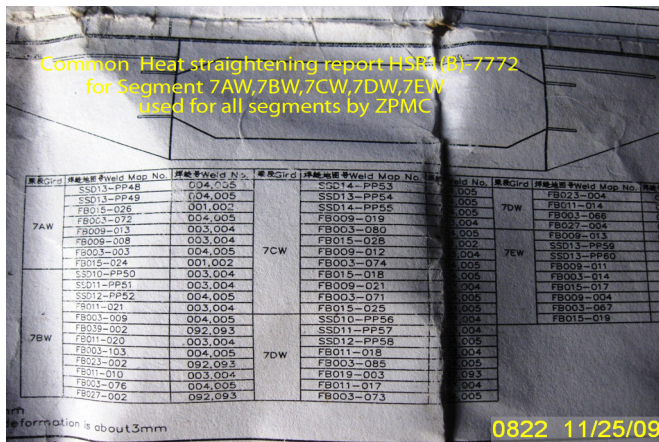
BAY#19

SAW welding of weld joint 1G-002 located on PCMK BP025 -012 of CB13 welder is identified as 062816. ZPMC QC is identified as Mr. Zhu zhong hai. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2C-S-2.

## OUTSIDE SEGMENT

ZPMC is doing heat straightening on segment 7CW, they using Jack and chain block to hold down the Floor beams at panel point PP53,54 Floor beam flange (FL-2). They using one HSR report no is HSR1(B)-7772 dated on 2009.10.19 for segment 7AW,7BW,7CW,7DW,7EW.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.



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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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